

IN THE ABSTRACT:

Please replace the existing Abstract with the following Abstract.

A laser machining apparatus capable of changing a laser output condition at a desired machining position and time without regard to an interpolation period (ITP). When the remaining motion command amount P_a in the former of successive blocks, used for the interpolation period Q_0 between these blocks, is less than a motion command amount corresponding to a command speed in the ~~interpolation period~~ ITP , such deficiency P_b is supplemented by a motion command for the latter block, thus maintaining a moving speed unchanged. The laser output condition is changed between the blocks. ~~A time period $t_1 = ITP \cdot P_a / (P_a + P_b)$ from when the interpolation period Q_0 between the blocks starts to when a change from the former block to the latter is completed is determined.~~ In an interpolation period ITP $Q-1$, a CNC sets the time period t_1 and the laser output condition in laser output control signal generating means-unit which changes the laser output condition when the time period t_1 has elapsed from the start of the ~~interpolation period~~ ITP Q_0 , making it possible to change the laser output condition at an arbitrary time without being limited by the interpolation period ITP , ~~whereby a highly accurate laser machining can be achieved.~~